

ABSTRACT

A mold for injection molding which is comprised of a mold cavity having an inside shape fit to an outside shape of a target product and a temporary space being communicated with the mold cavity and is eliminated before an amount of a molten material being injected to the mold cavity reaches the capacity of the mold cavity.

Said mold cavity has two or more gates that can be controlled of start of injection respectively, and, said temporary space is a ditch 126 which has an eliminator to eliminate itself and is set on the surface of the mold cavity where it connects opening portions of the two gates 111 and 112 that are mutually adjacent, and, the second gate 112 is set to be opened after a melt-front of a molten resin injected from the first gate 111 reaches the position of said second gate 112, a molten resin being progressed in the ditch 126 is pushed and returned to the mold cavity by using the eliminator, and, said eliminator is started when a melt-front of a molten resin from said first gate 111 reaches the position of said second gate 112.

(12)特許協力条約に基づいて公開された国際

(19)世界知的所有権機関
国際事務局(43)国際公開日
2004年8月5日 (05.08.2004)

PCT

Rec'd PCT/PTO 20 JUL 2005

10/542876

(10)国際公開番号

WO 2004/065096 A1

(51)国際特許分類⁷: B29C 45/26

(21)国際出願番号: PCT/JP2004/000438

(22)国際出願日: 2004年1月20日 (20.01.2004)

(25)国際出願の言語: 日本語

(26)国際公開の言語: 日本語

(30)優先権データ:
特願2003-012183 2003年1月21日 (21.01.2003) JP
特願2003-149920 2003年5月27日 (27.05.2003) JP
特願2003-152638 2003年5月29日 (29.05.2003) JP

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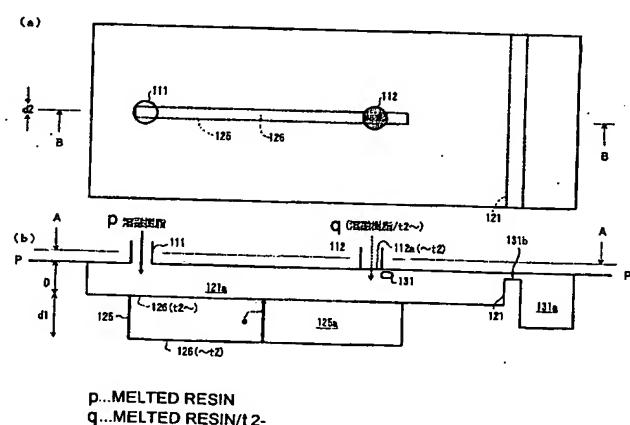
(81)指定国(表示のない限り、全ての種類の国内保護が可能): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84)指定国(表示のない限り、全ての種類の広域保護が可能): ARIPO (BW, GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), ユーラシア (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), ヨーロッパ (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU,

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(54) Title: INJECTION MOLDING DIE, INJECTION MOLDING METHOD, AND WELDLESS MOLDED PRODUCT

(54)発明の名称: 射出成形金型、射出成形方法、及びウエルドレス成形品



(57) Abstract: An injection molding die has gates for injecting a melted material to a cavity. In the die, injection timing of a melted material can be set for each gate, and an extra space is formed as an elongate groove portion (126) provided at a place, in a section that connects openings of adjacent gates, on the side projecting from a surface of an objective molded product. The timing of injecting the melted material from each gate is set such that, when the head of flow of the melted material pressed in from one (111) of the adjacent gates and advanced along the groove portion passes the position of the other gate (112), the melted material is started to be pressed in from the other gate (112). The die has eliminating means for eliminating the groove portion by pushing back the melted material in the groove portion (126) into the inside of the cavity. Eliminating operation by the eliminating means is performed after the head of flow of the melted material, pressed in from the one (111) of the adjacent gates and advanced along the groove portion (126), has passed the position of the other gate (112).

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